

Date: Tuesday, 21/10/2008 8:14:36 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD BLADE FOLD ASSY WELDMENT

Job Number: 42753

Part Number: PB674300107

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



(x2)

Comment: LARGE FABRICATION RESOURCE 1

1- assemble parts on jig DT8813 and weld as per dwg PB67-43001

*** ensure no burn thru after welding in tube -205 and -197 only where bushing -265 **

PL 08-10-27

08-10-27

14.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08/10/28 (2)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/10/28 (1)

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

mask inside of D3440-5, D3440-7 and D3440-15 prior to paint*

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME:

12:55

OVEN TEMPERATURE:

320°

FINISH TIME:

1:25

08/10/28

(2)

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/10/28

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Carl

MF 08-10-28

19.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(2)

08/10/28

Job Completion



MF 08-10-28

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Job Number: 42753

Part Number: PB674300107

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PB6743001201

Square Tubing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)
Square Tubing 40592
batch:- ~~B41512~~

MF 08-10-21

7.0

PB6743001203

Square Tube



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)
Square Tube
batch:- B41789

MF 08-10-21

8.0

PB6743001207

Square Tube



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)
Square Tube
batch:- B42603

MF 08-10-21

9.0

PB6743001219

Angled Male Eye



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)
Angled Male Eye
batch:- B40041

MF 08-10-21

10.0

D34405

Contoured Detent Clip Base (Supersedes B



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)
Contoured Detent Clip Base
batch:- B41454

MF 08-10-21

11.0

D34407

Detent Clip Base (Supersedes B67-43001-2



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)
Detent Clip Base
batch:- B41204

MF 08-10-21

12.0

D344015

Contoured Male Eye (Supersedes B67-43001



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)
Contoured Male Eye
batch:- B41202

MF 08-10-21

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Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	FWD BLADE FOLD ASSY WELDMENT
Job Number :	42753		
Estimate Number :	13418		
P.O. Number :		Part Number :	PB674300107
This Issue :	21/10/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	B6743001 P.5
First Issue :	//	Project Number :	N/A
Previous Run :	41362	Drawing Revision :	B1
	Type :	Material :	
	LARGE FAB ASSY	Due Date :	28/10/2008
Written By :		Qty:	2
Checked & Approved By :	<u>MF 08-10-21</u>	Um:	Each
Comment :	Est Rev:A 08-06-25 new issue DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PB674300147	Base Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Base Assembly

batch:- B41507MF08-10-21

2.0	PB6743001205	Outer Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Outer Tube

batch:- B41485MF08-10-21

3.0	PB6743001197	Outer Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Outer Tube

batch:- B41483MF08-10-21

4.0	PB6743001211	Square Tubing
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Comment: Qty.: 6.0000 Each(s)/Unit Total : 12.0000 Each(s)

Square Tubing

batch:- B41487MF08-10-21

5.0	PB6743001209	Square Tubing
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Square Tubing

batch:- B40555MF08-10-21